

Work Order ID 66191

Monday, February 07, 2011 11:56:23 AM



Page 1

Item ID:	D3296-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Panel					
Start Date:	2/8/2011	Start Qty: 6.00		Cust Item ID:		
Required Date:	2/22/2011	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-02-07</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	Rev A								

100	FLOW WATER JET	0.00							
	Waterjet	Memo	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D3296	<input type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-					
2024 .063	Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

120	QC8- Inspect parts - second check	0.00							
	QC	Memo	0.00						
Quality Control									

11-2-17

6

11-2-17

11 02 17 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66191

Monday, February 07, 2011 11:56:23 AM

Page 2

Item ID: D3296-3

Accept

Revision ID:

Item Name: Door Panel

Start Date: 2/8/2011 Start Qty: 6.00

Required Date: 2/22/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr

B11-2-17

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

6 p 11/02/12

150



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

6 BR 11-02-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, February 07, 2011 11:56:23 AM

Page 3

Item ID: D3296-3

Accept

Revision ID:

Item Name: Door Panel

Start Date: 2/8/2011 Start Qty: 6.00

Required Date: 2/22/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 196

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/2/23 (E)

11/02/23 (J)

11-02-23 (6)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 11:56:21 AM

Page 1

Work Order ID: 66191



Parent Item: D3296-3



Parent Item Name: Door Panel


Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			110	sf	31.9270	0.6532	4.125474			
2024-T3 .063 sheet													



1811-2-17

Location

Loc Qty

Loc Code

MAT22

31.927

114351

31.927

114351

6

W/O:		WORK ORDER CHANGES					
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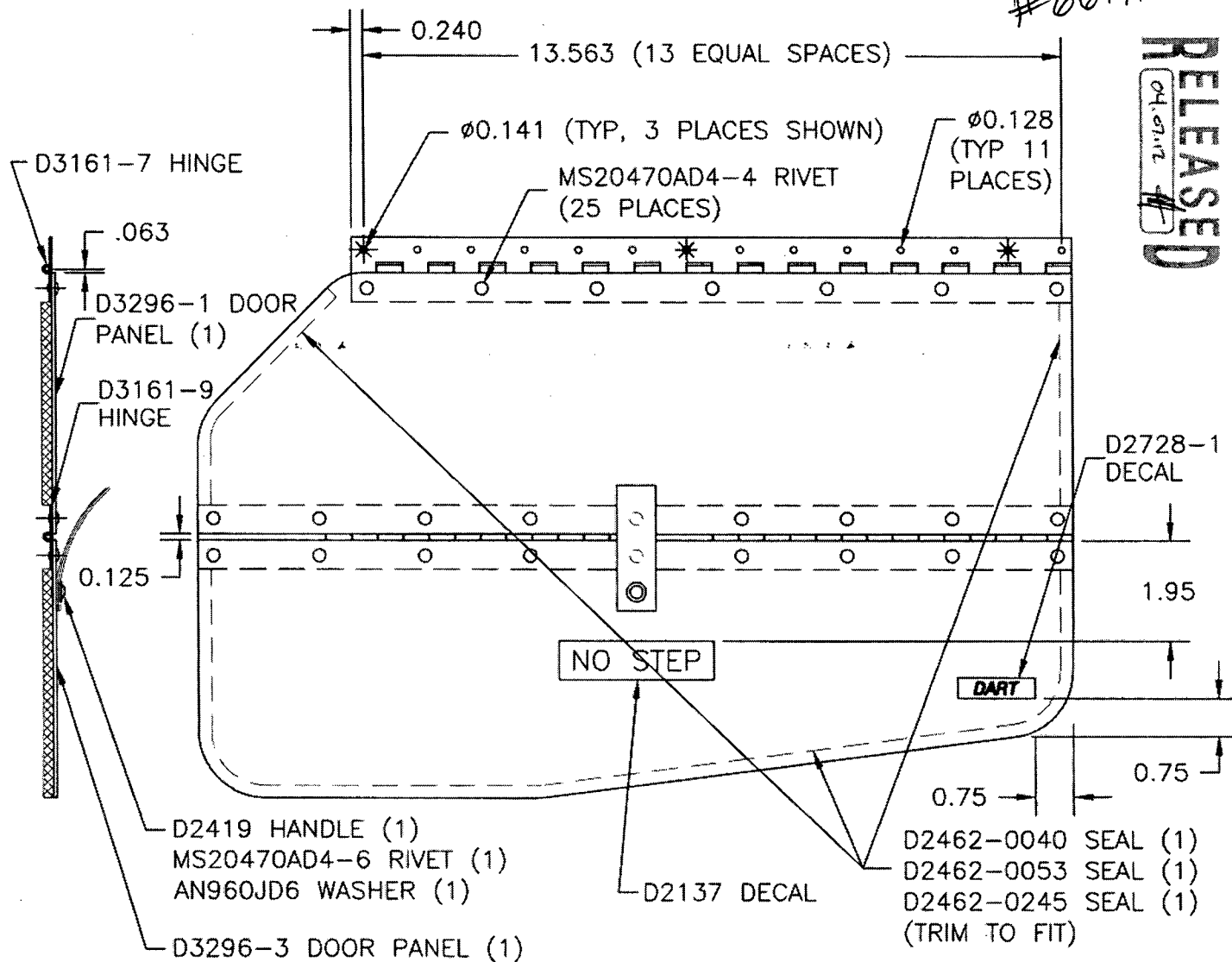
NOTE: Date & initial all entries

DART



RELEASED
04.01.12

#66191



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
04.06.28	D3296	1 OF 2
A	TITLE	SCALE
04.06.28	DOOR ASSEMBLY	1:3
NEW ISSUE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

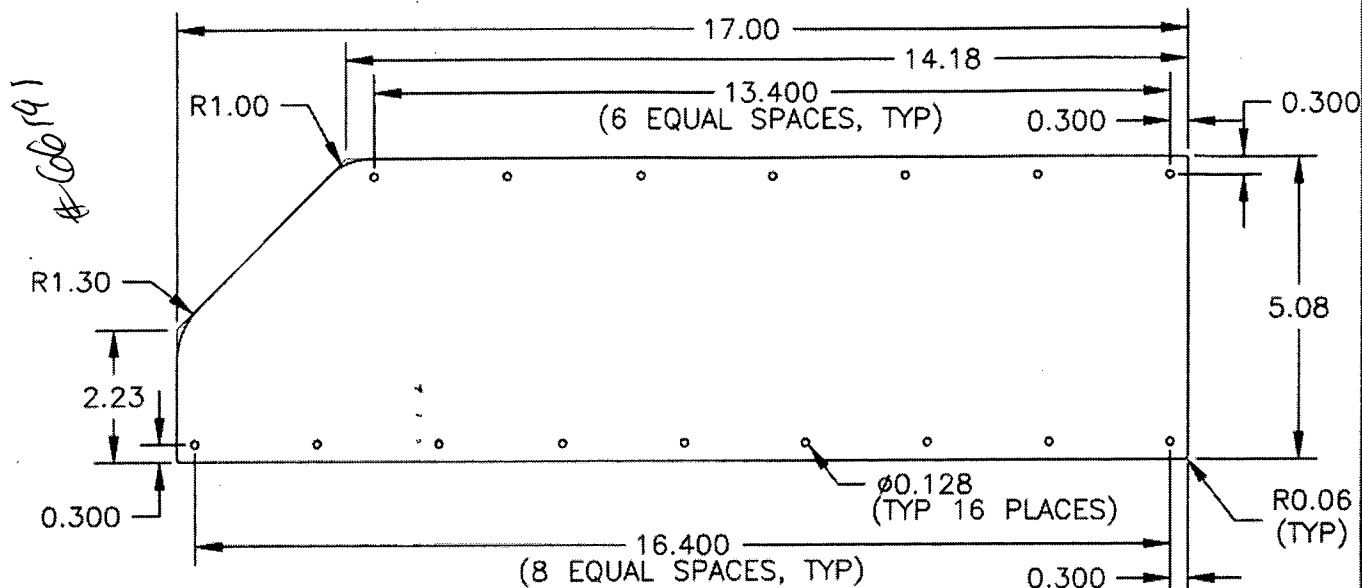
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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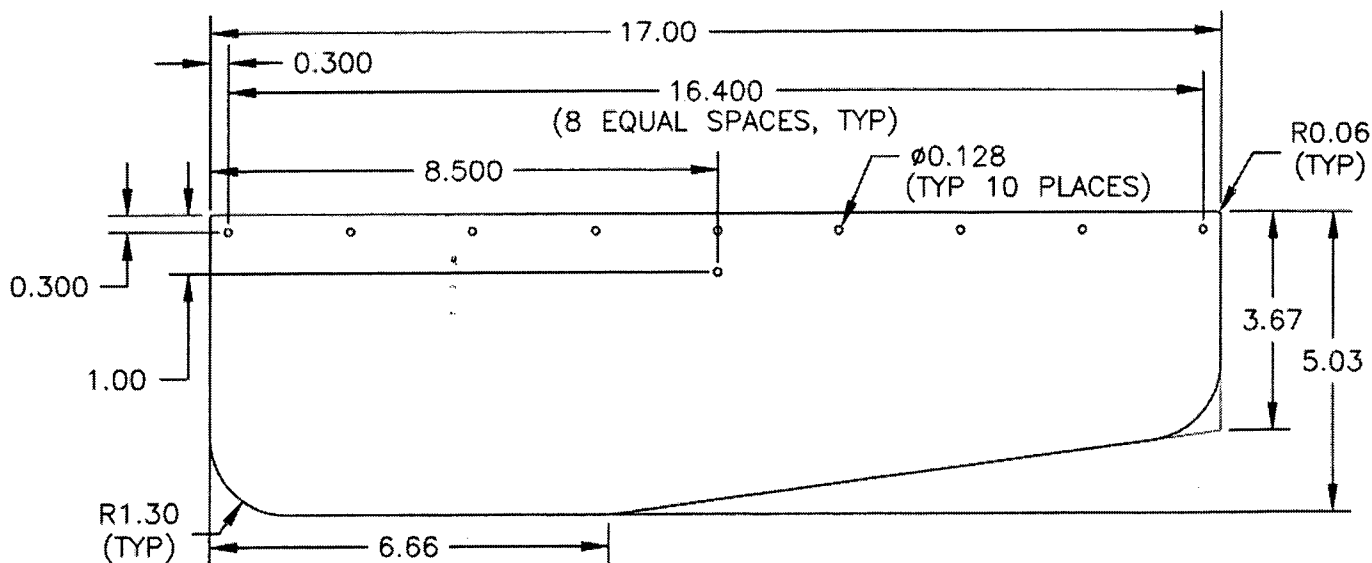
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12 *HA*

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